

Work Order ID : 112314***112314***

Page 1

January-30-14 11:30:53 AM

D 3 5 6 4 - 1 1

Accept

Item ID: D3564-11

N900040100

Setup Start

NS1

Revision ID:

B 1 1 2 3 1 4

Item Name: Stainless Steel Wearplate Aft

Stop

NS2

Start Date: 1/30/14 Start Qty: 8.00

8 ***12***

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan: ML5Date: 14-01-31

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								

100

100

Waterjet

FLOW WATER JET

0.00

12AE
14.02.14

FLOW CNC Waterjet

Memo
1-Cut as per Dwg D3564 ***** (D3564-1F)***** Dwg Rev: D Prog
Rev: D 2-Deburr if necessary

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

12AE
14.02.14

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

DAS
27
3.59
14/2/1812AE

DQA: _____ Date: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order ID 112314***112314***

Page 2

January-30-14 11:30:53 AM

Item ID: D3564-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Stainless Steel Wearplate Aft

Stop

NS2

Start Date: 1/30/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan

Accept

Reject

Reject

Run

Start

NR1

130

130

Brake NC

NC BRAKE

0.00

DAS

DAS
30
9-89

12

14/02/19

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

12

150

150

Large Fab

Large Fab

0.00

14/02/19

12

14-02-26

Large Fab

Qty Description Batch A/R 2059B Hardcoat
1126834 Weld hardcoat as per Dwg D3437

JL

DQA: _____ Date: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
Suspected Unapproved <input type="checkbox"/>		Large Fab <input type="checkbox"/>		Composite <input type="checkbox"/>		Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
			Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>					Pressure/Forced <input type="checkbox"/>
			Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>					Set-up <input type="checkbox"/>
			Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>					Temperature/Cure <input type="checkbox"/>
			Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>					Weld <input type="checkbox"/>
			Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>					Wrong Stock Pulled <input type="checkbox"/>
			Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>					
			Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>					
			Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>						
			Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>						
			Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>						
			Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>						
<p>_____</p> <p>_____</p> <p>_____</p>											

Work Order ID 112314

112314

January-30-14 11:30:53 AM

Page 3

Item ID: D3564-11

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Stainless Steel Wearplate Aft

Stop

NS2

Start Date: 1/30/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

OC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

(12)

14.02.26

DAS

9

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

180

Powdercoat

Powder Coating

Memo

11:10

START TIME:

OVEN TEMPERATURE:

320

FINISH TIME:

11:40

(12)

14.02.26

DAS

9

9-89

DAS

34

9-89

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design <input type="checkbox"/>											
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Handling/Pre <input type="checkbox"/>											
Material <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Offset/Setup <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Transport <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear			General								
			Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>				
			Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>				
			Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>				
			Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>				
			Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>				
			Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>					
			Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>					
			Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>	Other <input type="checkbox"/>					
			Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>						
			Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>						
			Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>						

Work Order ID 112314***112314***

Page 4

January-30-14 11:30:53 AM

Item ID: D3564-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Stainless Steel Wearplate Aft

Stop

NS2

Start Date: 1/30/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

Spn
14/1/27

10

190

QC

Quality Control

200

Identify as per dwg & Stock Location: FP-002 0.00***200***

Packaging

Packaging

0.00

X/2 6/20 1/27

210

QC21- Final Inspection - Work Order Release 0.00

0.00

210

QC

Quality Control

Memo

MLJ 14-2-28

MF
14-2-27

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Folio/Program	Outside Dimensions
Bending	Bend	Grain	Over/Under tolerance
Centre Not Concentric	BOM/Route	Hardware	Part Incorrect
Cracks	Broken/Damage/Defect	Inspection Incomplete/Unqualified	Part Lost/Missing
Crimp/Kink/Ripple/Wave	Burrs	Instructions Incomplete/Unclear	Part Moved
Cuffs	Contamination	Misaligned/off center	Positioned Wrong
Crushing	Countersink	Mislabeled	Power Loss/Surge
Heat Treat	Cut Too Short	Misread	Pressure/Forced
Inspection Strip in Tube	Drawing	Off-set	Set-up
Marks/Chatter	Drill Holes	Out of Calibration	Temperature/Cure
Turning Sequence	Finish	Out of Sequence	Weld
Wave/Twist in Tube	Fit/Function		Wrong Stock Pulled
			Other

Picklist Print

January-30-14 11:30:52 AM

Page 1

Work Order ID: 112314

Parent Item: D3564-11

Start Date: 1/30/14

Required Date: 1/30/14

Parent Item Name: Stainless Steel Wearplate Aft

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-03-08 ec

IPP Rev:B As per Rev C 07-07-09 JLM

IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	369.0170	1.41	11.873684		Ac 14-02-14	

Location	Loc Qty	Loc Code
MAT020	369.017	
M126915	2.487	
M127821	166.53	
M128054	200	

12.3

DQA: _____ Date: _____

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only



Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function								
			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence								
			<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge								
			<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled								
			<input type="checkbox"/> Other								

DART AEROSPACE LTD	Work Order:	112314
Description: Wearshoe	Part Number:	D3564-11
Inspection Dwg: D3564 Rev: D		Page 1 of 1

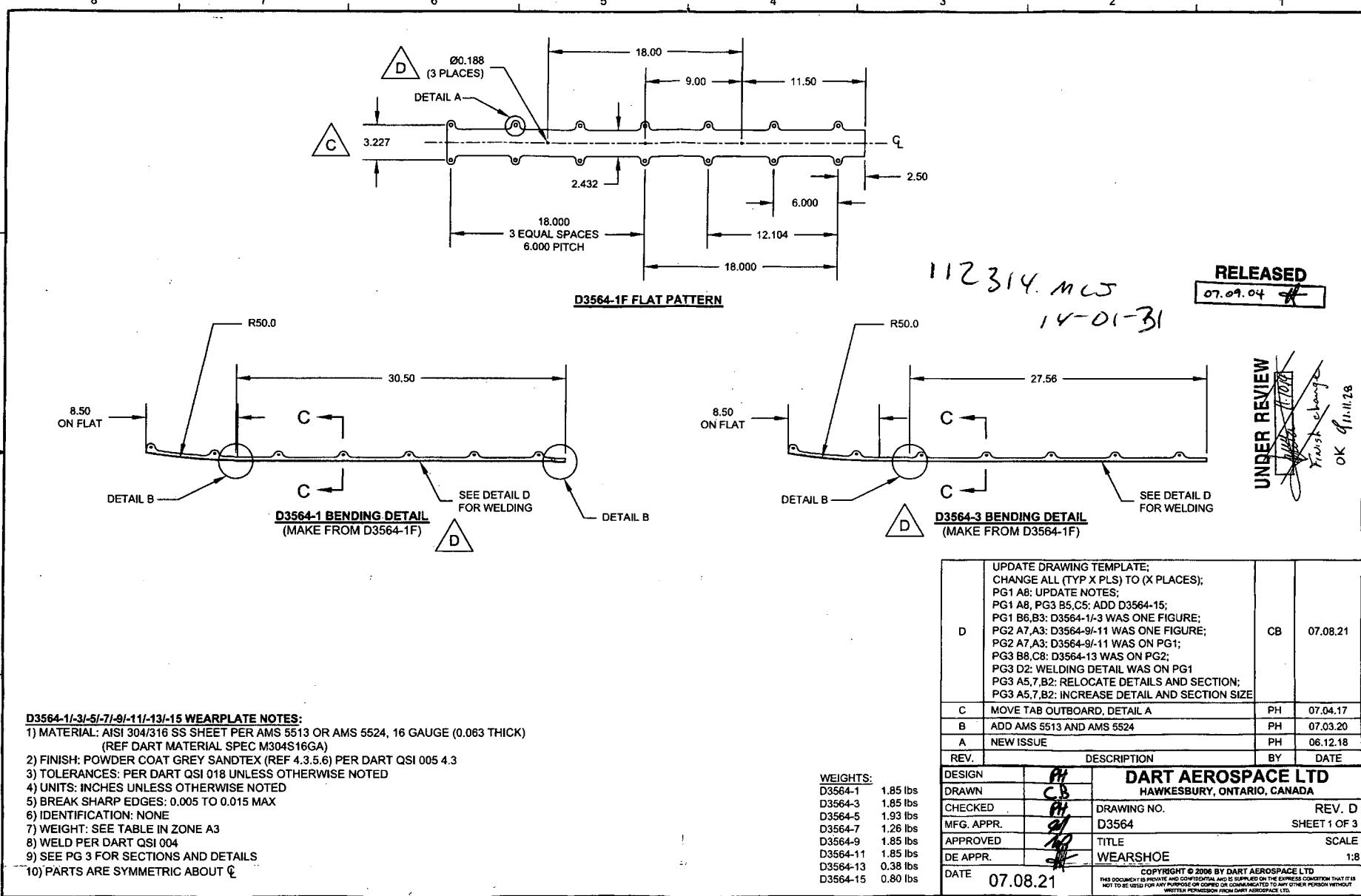
FIRST ARTICLE INSPECTION CHECKLIST

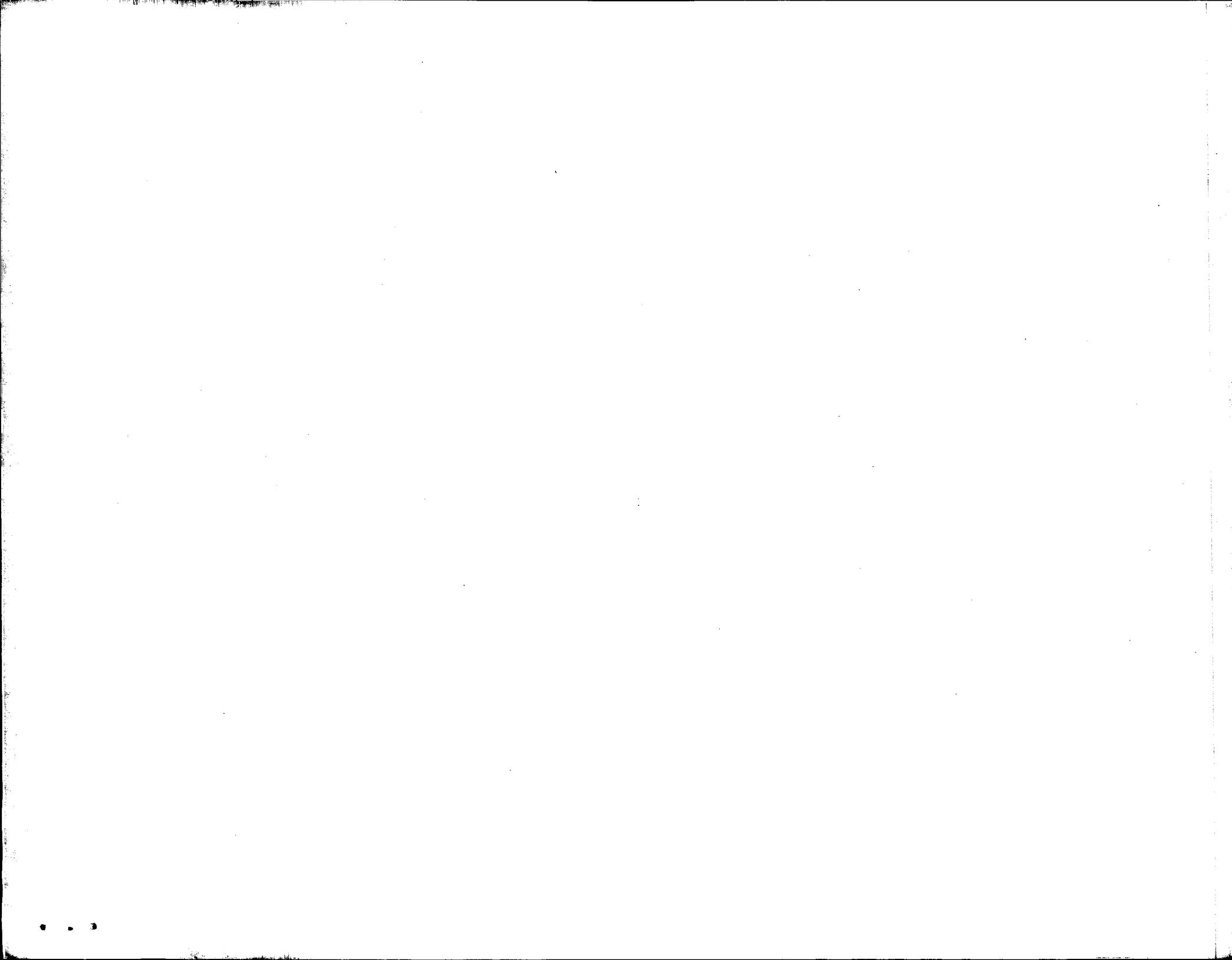
X First Article Prototype

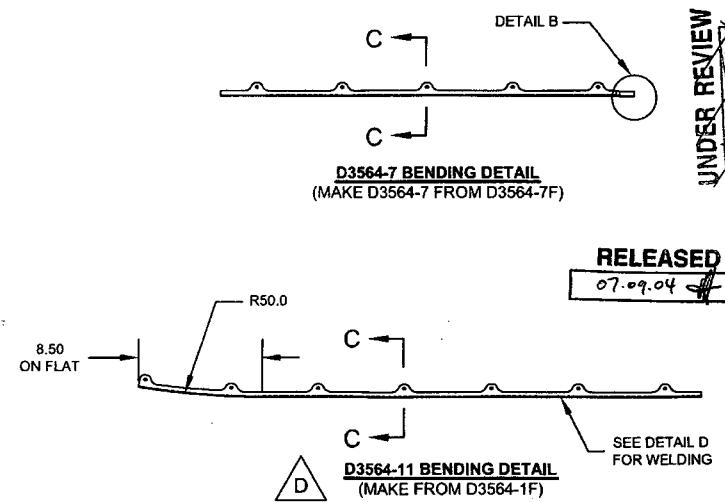
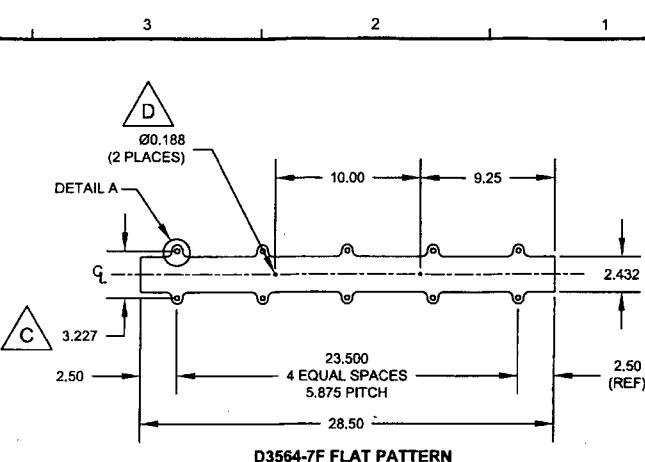
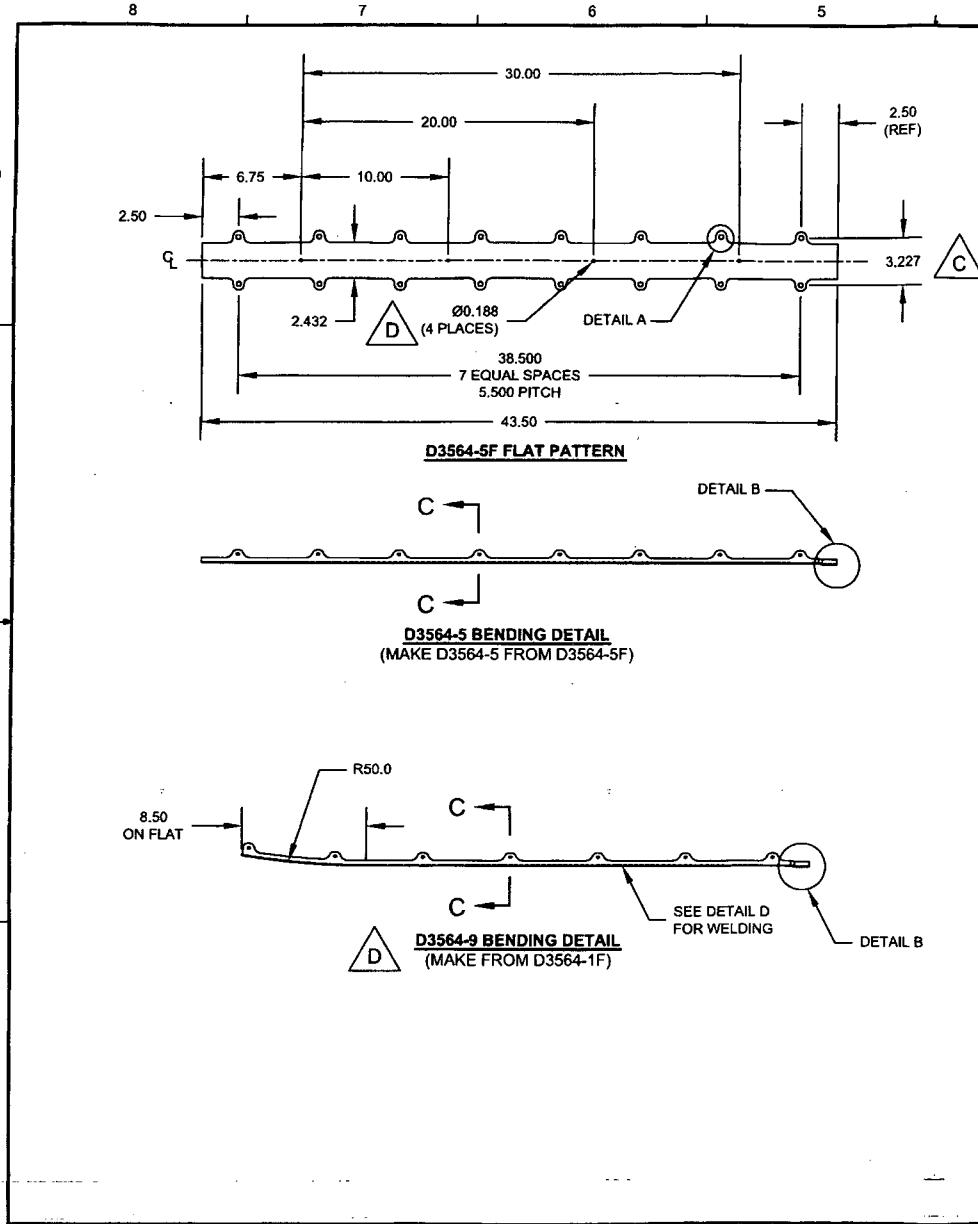
27

Measured by:	<u>AE</u>	Audited by:	<u>3-89</u>	Prototype Approval:	N/A
Date:	<u>14.02.14</u>	Date:	<u>14/2/18</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	KA N





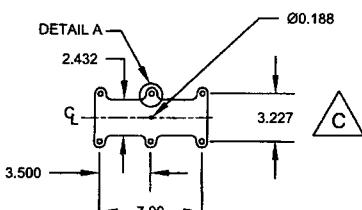


UNDER REVIEW
OK C.I.I. 28
OK C.I.I. 28

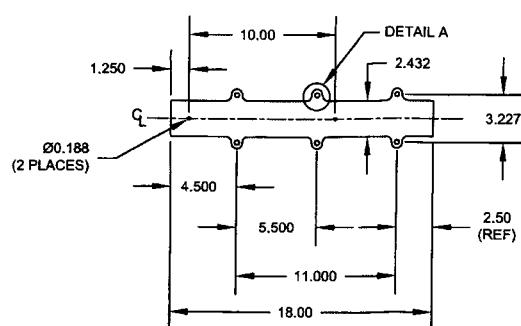
RELEASED
07-09-04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	REV. D	
MFG. APPR.	SI	DRAWING NO. D3564	
APPROVED	NO	SHEET 2 OF 3	
DE APPR.	SI	TITLE WEARSHOE	
DATE	07.08.21	SCALE 1:8	

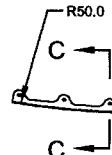
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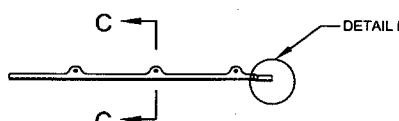
D3564-13F FLAT PATTERN



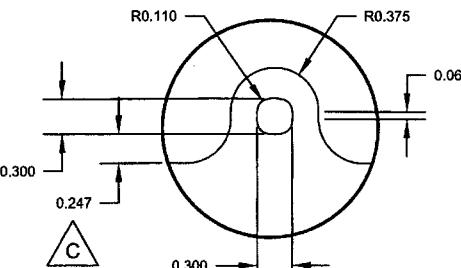
D3564-15F FLAT PATTERN



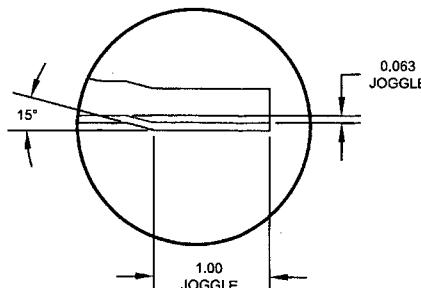
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



DETAIL A
SCALE 1:1

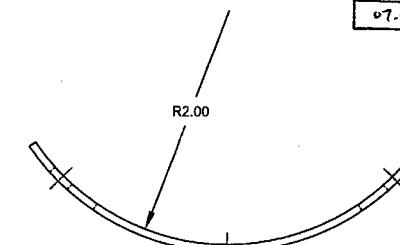


DETAIL B

2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308

DETAIL D

RELEASED
07-09-04



SECTION C-0
SCALE 1:1

~~UNDER REVIEW~~ 11/11/28

DESIGN	<u>PH</u>	DART AEROSPACE LTD	
DRAWN	<u>CB</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>PH</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>SI</u>	D3564	SHEET 3 OF 3
APPROVED	<u>NO</u>	TITLE	SCALE
DE APPR.	<u>SI</u>	WEARSHOE	1:1
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